

Work Order ID 51671

August 27, 2009 8:41:01 AM

Page 1

Item ID: D3535-15 *6Y*

Accept

Revision ID: B

Item Name: Wearshoe

Start Date: 8/27/09

Start Qty: 18.00

Required Date: 9/18/09

Req'd Qty: 18.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *RL mt*

Date: *09-27*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3535

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

*304
dtD*

1-Cut as per Dwg D3535 11Dwg Rev: *B* 11Prog Rev: *B* 112-
Deburr if necessary

B9-10-7

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B9-10-7

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

27 502/10108

(418)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51671

August 27, 2009 8:41:01 AM



Item ID: D3535-15

Accept



Setup Start



Revision ID: B

Stop



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Start Date: 8/27/09

Start Qty: 18.00



Cust Item ID:

Required Date: 9/18/09

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326
joggle as per Dwg D3535 using Jig DT8158 13-Identify as D3535-15

SB 09/10/09

18

00

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

2) S 09/10/09

788

150

0.00



Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

Powdercoat

Memo

0.00

Powder Coating

START TIME:

7:15

COVEN TEMPERATURE:

300° FINISH TIME:

7:45

BR 09-10-9

18

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51671

August 27, 2009 8:41:01 AM



Page 3

Item ID: D3535-15

Accept



Setup Start



Revision ID: B

Stop



Item Name: Wearshoe

Start Date: 8/27/09

Start Qty: 18.00



Cust Item ID:

Required Date: 9/18/09

Req'd Qty: 18.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

U 09/10/09

(X18) 7

170



Packaging

Packaging

Identify as per dwg & Stock Location: FP-12

Memo

0.00

0.00

U 09/10/09

(X18) 7

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

09/10/13 H

u 09/10/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 8:41:00 AM

Page 1

Work Order ID: 51671



Parent Item: D3535-15RevB



Parent Item Name: Wearshoe

Start Date: 8/27/09

Required Date: 9/18/09

Comments:

Start Qty: 18.00

Required Qty: 18.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M304S20GA

Purchased

No

100

sf

63.3940

19.3358



139-10-7

304/316 .040 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

63.39404737

110076

31.73

111571

31.6640474

112567

112567

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 51679 51671
Description: Wearshoe		Part Number: D3535-15
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.889	X			
2.000	+/-0.010	2.000	X			
5.650	+/-0.010	5.650	X			
9.150	+/-0.010	9.150	X			
14.400	+/-0.010	14.400	X			
19.650	+/-0.010	19.650	X			
24.900	+/-0.010	24.900	X			
30.150	+/-0.010	30.150	X			
33.650	+/-0.010	33.650	X			
35.650	+/-0.010	35.650	X			
39.150	+/-0.010	39.150	X			
Ø0.188	+0.005/-0.001	.191	X			
24.00	+/-0.030	24.00	X			
16.00	+/-0.030	16.00	X			
8.00	+/-0.030	8.00	X			
5.00	+/-0.030	5.00	X			
0.300	+/-0.010	.301	X			
0.300	+/-0.010	.300	X			
0.038	+/-0.010	.037	X			

Measured by: <u>JB</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: <u>9-10-7</u>	Date: <u>02/10/08</u>	Date:	N/A

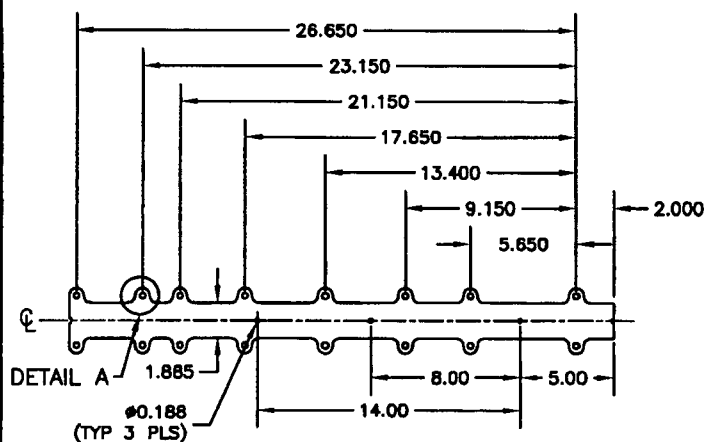
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	<u>BE</u>

DART

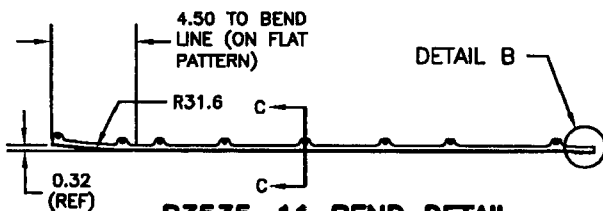
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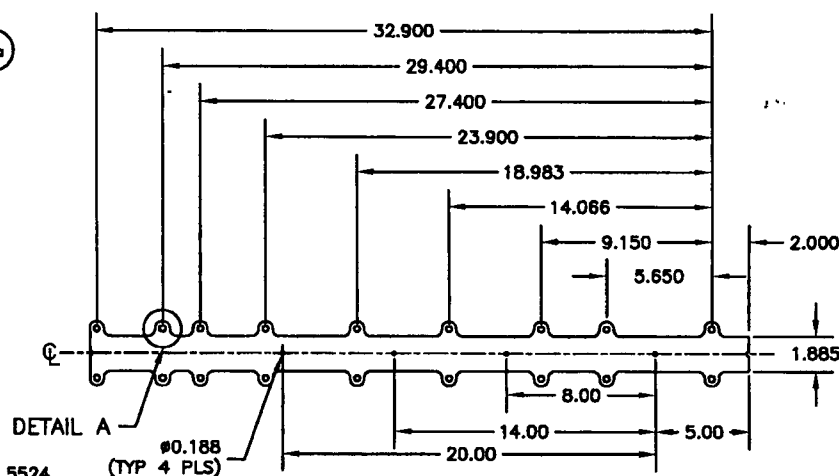
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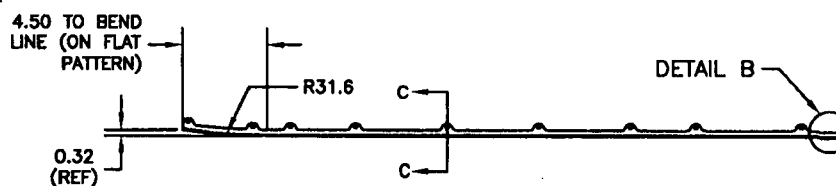
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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PH	PH	D3535
DATE	TITLE	SCALE
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A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

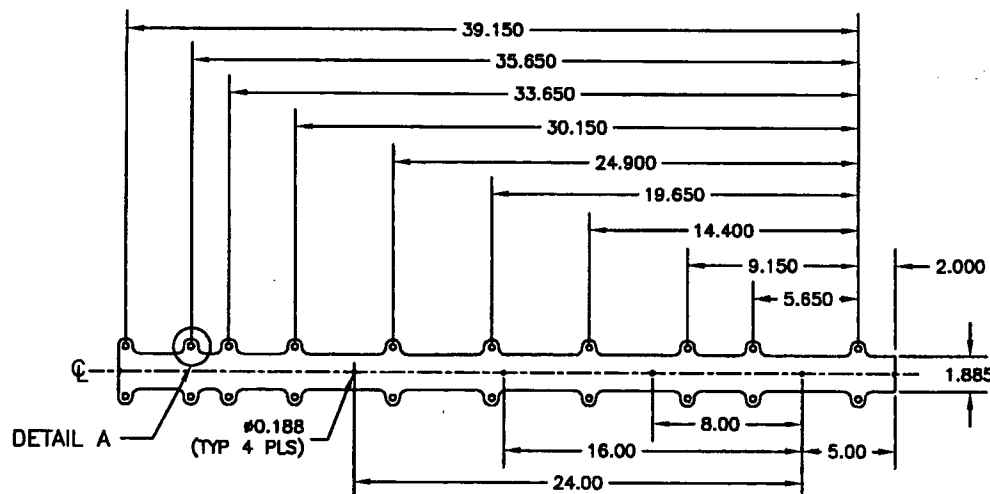
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		SHEET 2 OF 7		
		REV. B		

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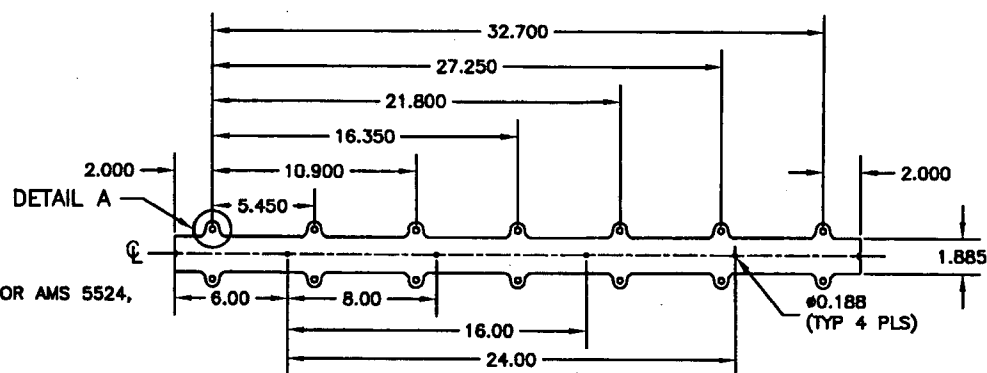


D3535-15F FLAT PATTERN

4.50 TO BEND
LINE (ON FLAT
PATTERN)

0.32
(REF)

D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN

DETAIL B

D3535-21 BEND DETAIL

NOTES

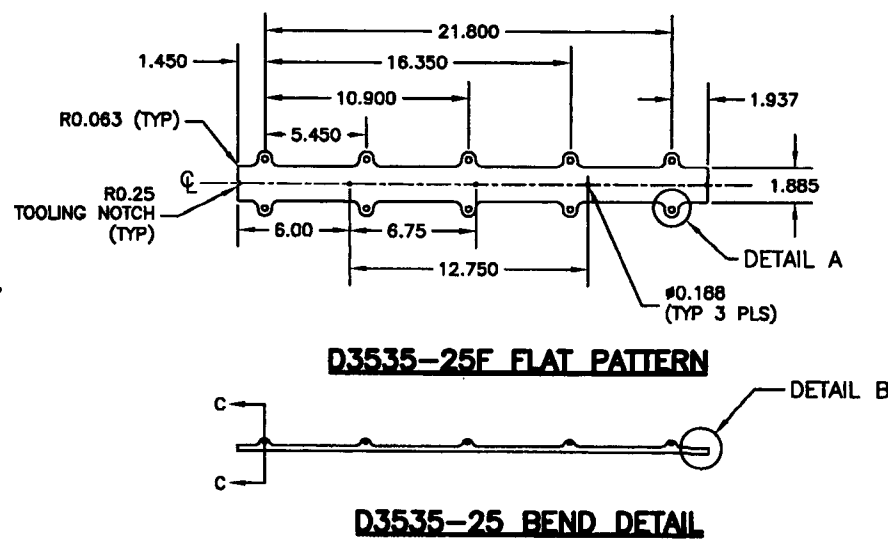
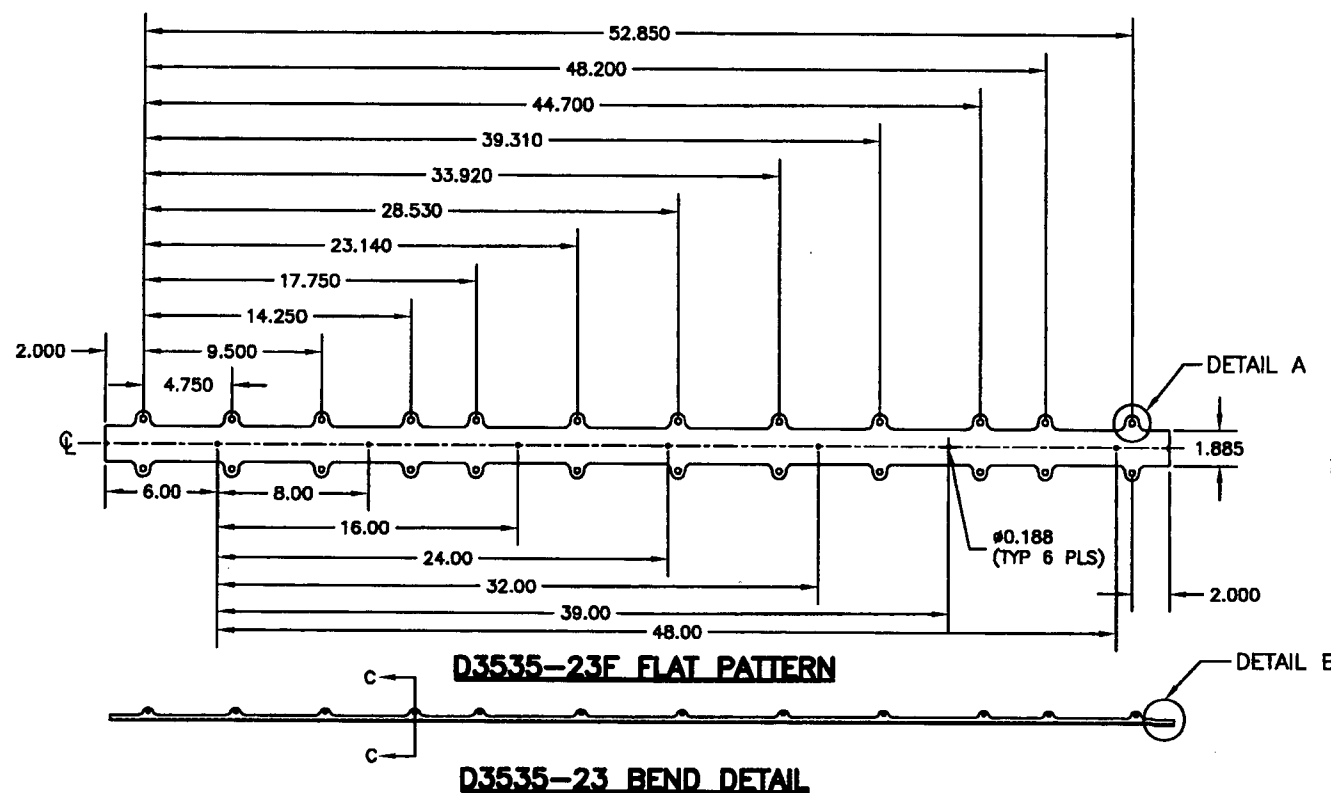
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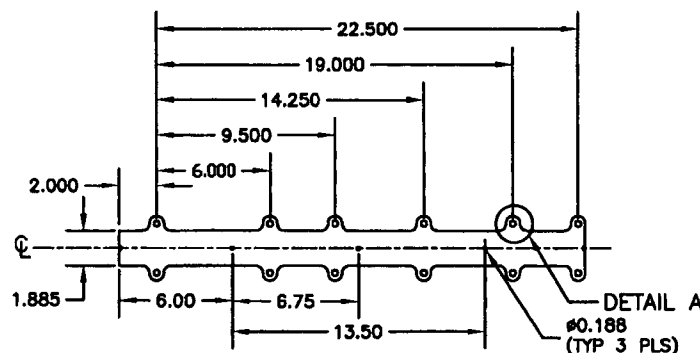


- NOTES**
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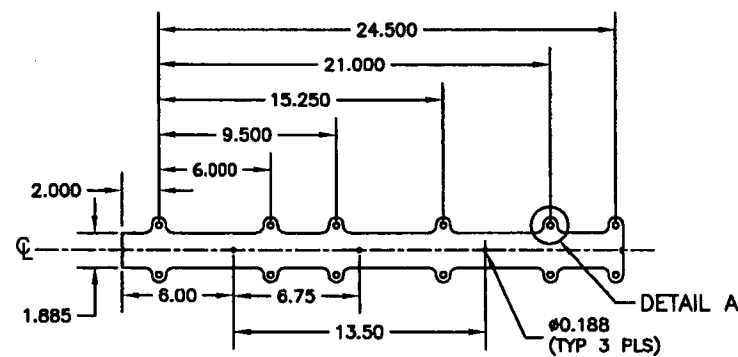
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NO. 51671



D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL



D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
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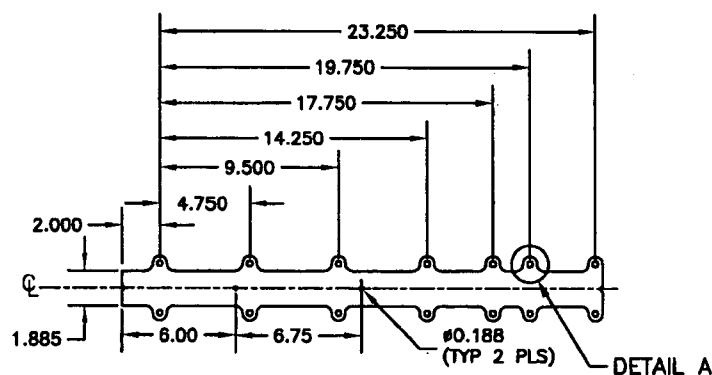
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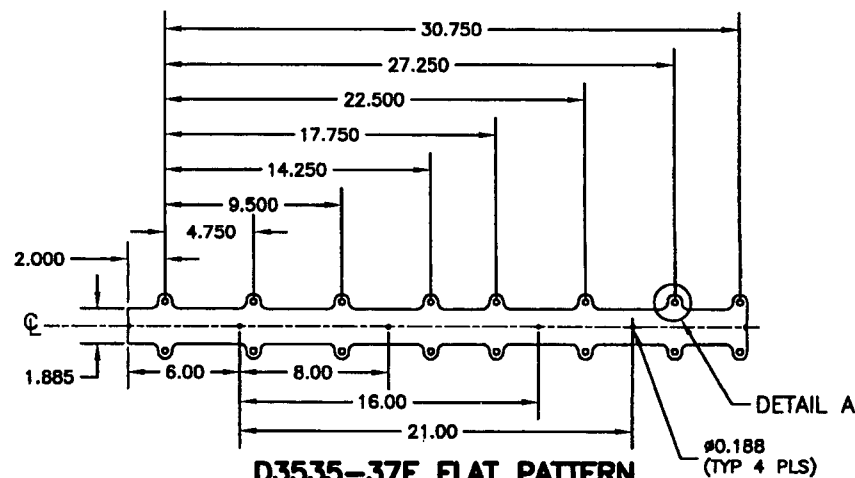
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D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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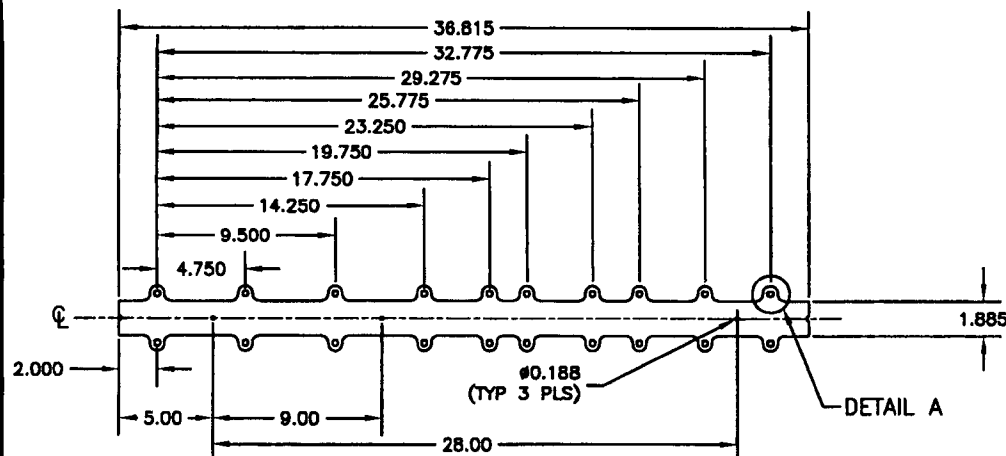
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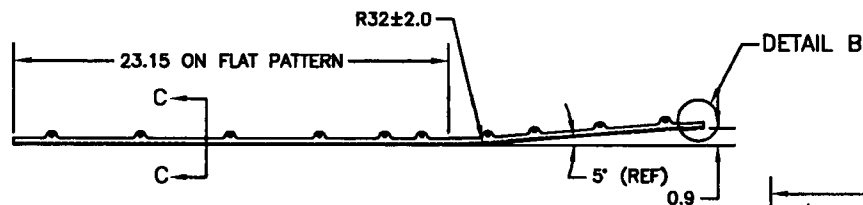
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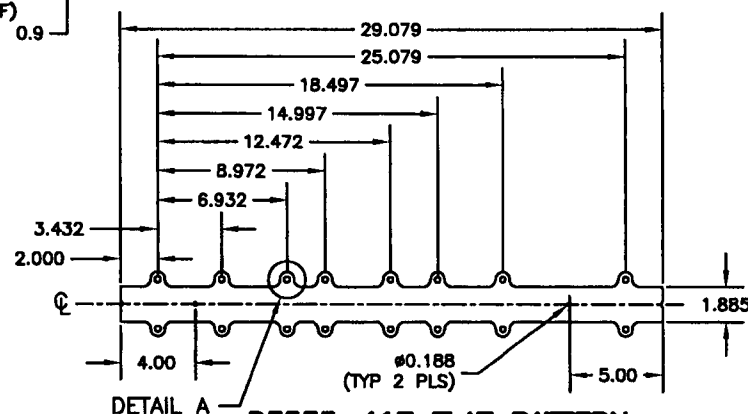
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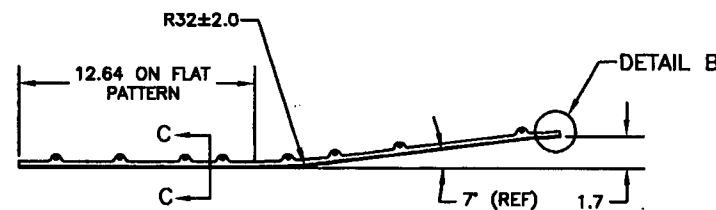
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

NOTES

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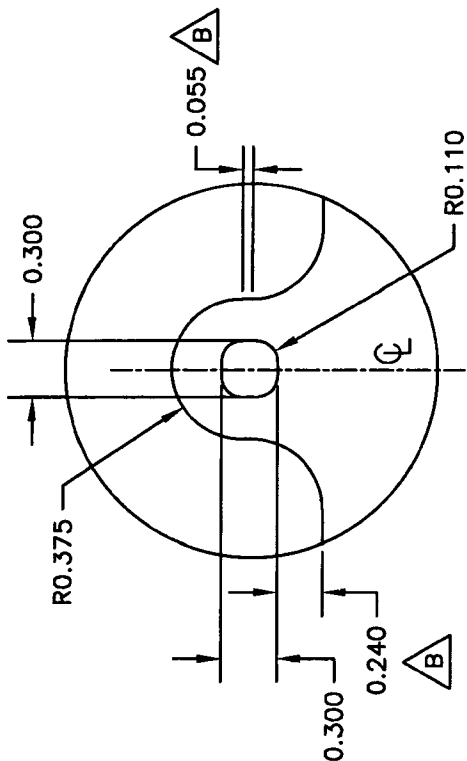


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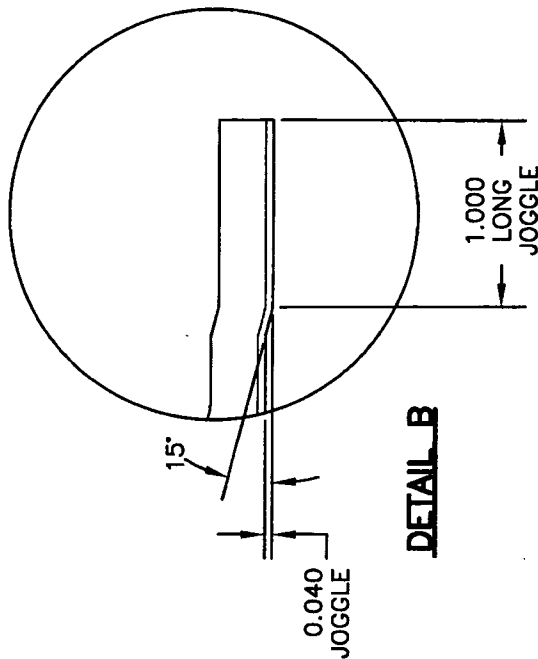
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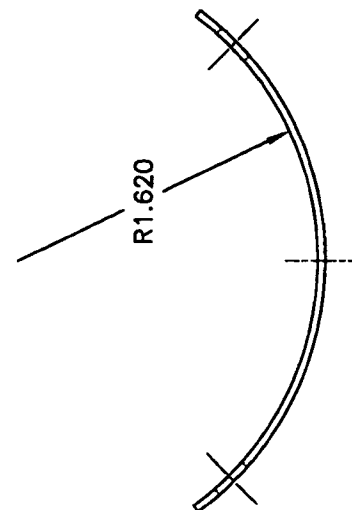
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DETAIL A



DETAIL B



SECTION C-C

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